

Date: Wednesday, 5/23/2007 4:11:04 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	32539			
Estimate Number	12712			
P.O. Number	N/A		Part Number	D35371
This Issue	5/23/2007	S.O. No. N/A	Drawing Number	D3537-UNDER REVIEW
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	XC <i>PT 07.05.24</i>
Previous Run	31998		Material	N/A
Written By			Due Date	6/4/2007
Checked & Approved By			Qty:	60
Comment	Est Rev: A	New Issue 07-02-14 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.0788 sf(s)/Unit Total: 4.7250 sf(s) M304S16GA .063" 304 SS SHEET Batch: M101873	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C	<i>SAD 07/06/01 60</i>
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 07/06/01 60</i>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>S.L. 07/06/01</i>
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	<i>SB 07/06/14 60</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32539		Part Number: D35371
Job Number:		
Seq. #:	Machine Or Operation:	Description:
6.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1  07/06/22 60
Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat M 102956 + M 104463 1-Weld as per Dwg D35371 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary		
7.0	QC9 	VISUAL WELDING INSPECTION  07/06/25 60
Comment: VISUAL WELDING INSPECTION		
8.0	QC5 	INSPECT WORK TO CURRENT STEP  07/06/25 60
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING 	POWDER COATING M 104846  60
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 BL/M/07-06-28		
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION F2  07/06/28 60
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	PACKAGING 1 	PACKAGING RESOURCE #1  60X
Comment: PACKAGING RESOURCE #1 Identify and Stock: FP-18 Location: M-h 07/06/28		
12.0	QC21 	FINAL INSPECTION/W/O RELEASE  07/06/29 60
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 W07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32539
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: B/C 07.05.24	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

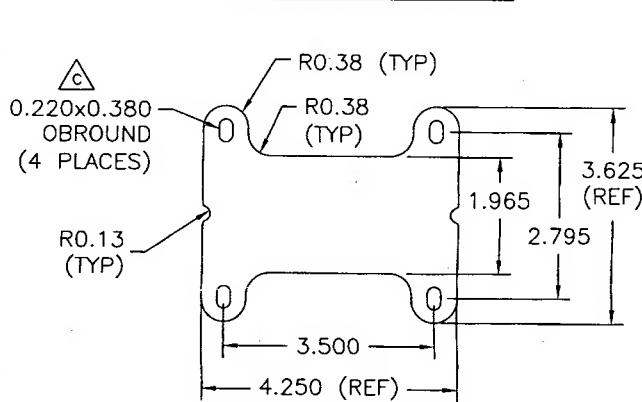
X First Article Prototype

pt
07.05.24

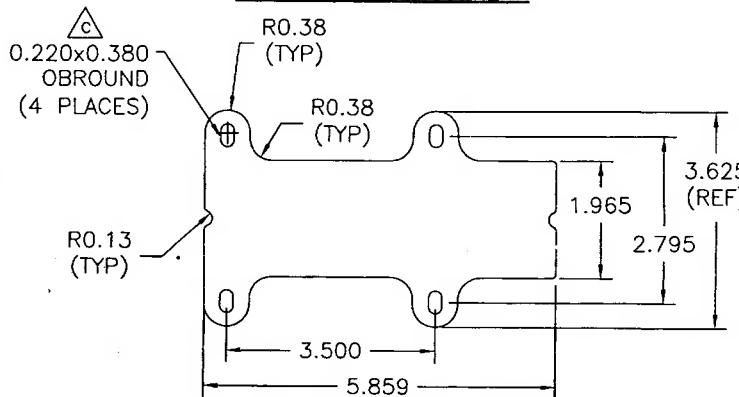
Measured by:	JAY	Audited by:	J.L.	Prototype Approval:	N/A
Date:	07/06/01	Date:	07/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	<i>[Signature]</i>

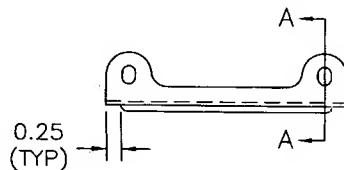
D3537-1F FLAT PATTERN



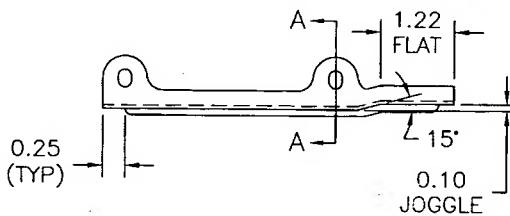
D3537-3F FLAT PATTERN



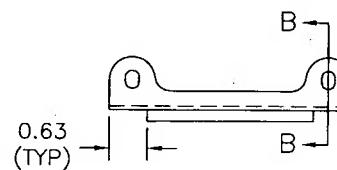
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1E)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET · PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEG. M304S16GA)

2) BREAK ALL SHARP CORNERS 0.063 MAX

3) WELD PER QSI 004

4) FINISH: POWDER COAT GREY SANTEX (4.5/5.6) PER QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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RETURN TO
ENGINEERING
CONTROLLED COPY
EFFECT TO AN AMENDMENT
WITHOUT NOTICE
WORK ORDER
32539

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3537
DATE 07.04.13	TITLE WEARPAD	REV. C SHEET 1 OF 1 1:2

